



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4034-041
Job Sheet 189044



Part No: D4034-041

Job Qty: 4 pcs

Part Name: Aft Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER
DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	2/15/19	2/15/19	0.00	0.00	Start Up Large Fab-6		
100	Large Fab - Basket - 1	4 pcs	2/15/19	2/15/19	0.00	4.60	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		CC
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	4 pcs	2/15/19	2/15/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		JS
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	2/15/19	2/15/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		JS
							QC 5 - 49		
							QC 5 - 51		

				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
130	Packaging 3-1 - Stock - B4B	4 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - SA	4 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

11

21 FEB 16 2019

Part Op **100** - (Weld per dwg A/R S.S. rod Batch: _____) 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld
 Descriptions: bushing in rib and grind weld flush as per dwg
110 - (QC9- Inspect visual per QSI004- Fusion Welds)
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA004
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 pcs (1 ea)	90-Start up Operation	5144786
D4021-9	Bushing	16 pcs (4 ea)	90-Start up Operation	5115312
D4034-1	Rib	4 pcs (1 ea)	90-Start up Operation	5142791
D4034-3	Rib	4 pcs (1 ea)	90-Start up Operation	5148705

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4021-7	4	18	0
	D4021-9	16	319	0
	D4034-1	4	17	0
	D4034-3	4	13	0
Part Specifications				
Specifications could not be found.				

Plex 1/21/19 4:29 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S153858



Part: D4034-041

Job No: 189044

Serial No/Batch: S153858

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/14/19



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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/15/19	0.00	0.00	Start Up Large Fab-6		<i>M42</i>
100	Large Fab	4 pcs		2/15/19	0.00	4.60	Large Fab 1		
110	QC	4 pcs		2/15/19	0.00	0.00	QC9		
120	QC	4 pcs		2/15/19	0.00	0.00	QC5		
130	Packaging	4 pcs		2/15/19	0.00	0.00	Packaging3 Large Fab		
140	QC21-SA	4 Ea		2/15/19	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld bushing in rib and grind weld flush as per dwg
Descriptions: 130 - LOCATION: WA004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 pcs (1 ea)	90-Start up Operation	<i>5144786</i>
D4021-9	Bushing	16 pcs (4 ea)	90-Start up Operation	<i>5115312</i>
D4034-1	Rib	4 pcs (1 ea)	90-Start up Operation	<i>5142791</i>
D4034-3	Rib	4 pcs (1 ea)	90-Start up Operation	<i>5148705</i>

Job Allocations

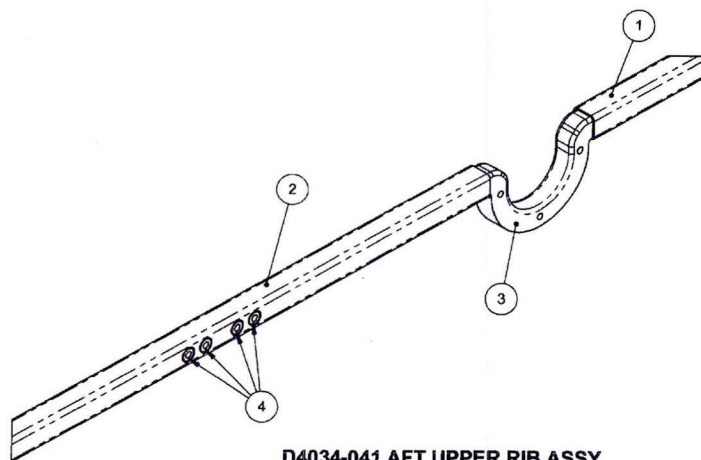
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4021-7	4	18	0
	D4021-9	16	319	0
	D4034-1	4	17	0
	D4034-3	4	13	0

Part Specifications

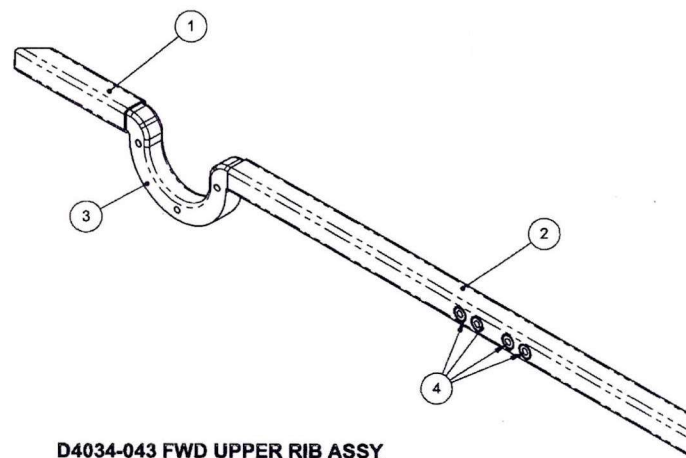
Specifications could not be found.

LF

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



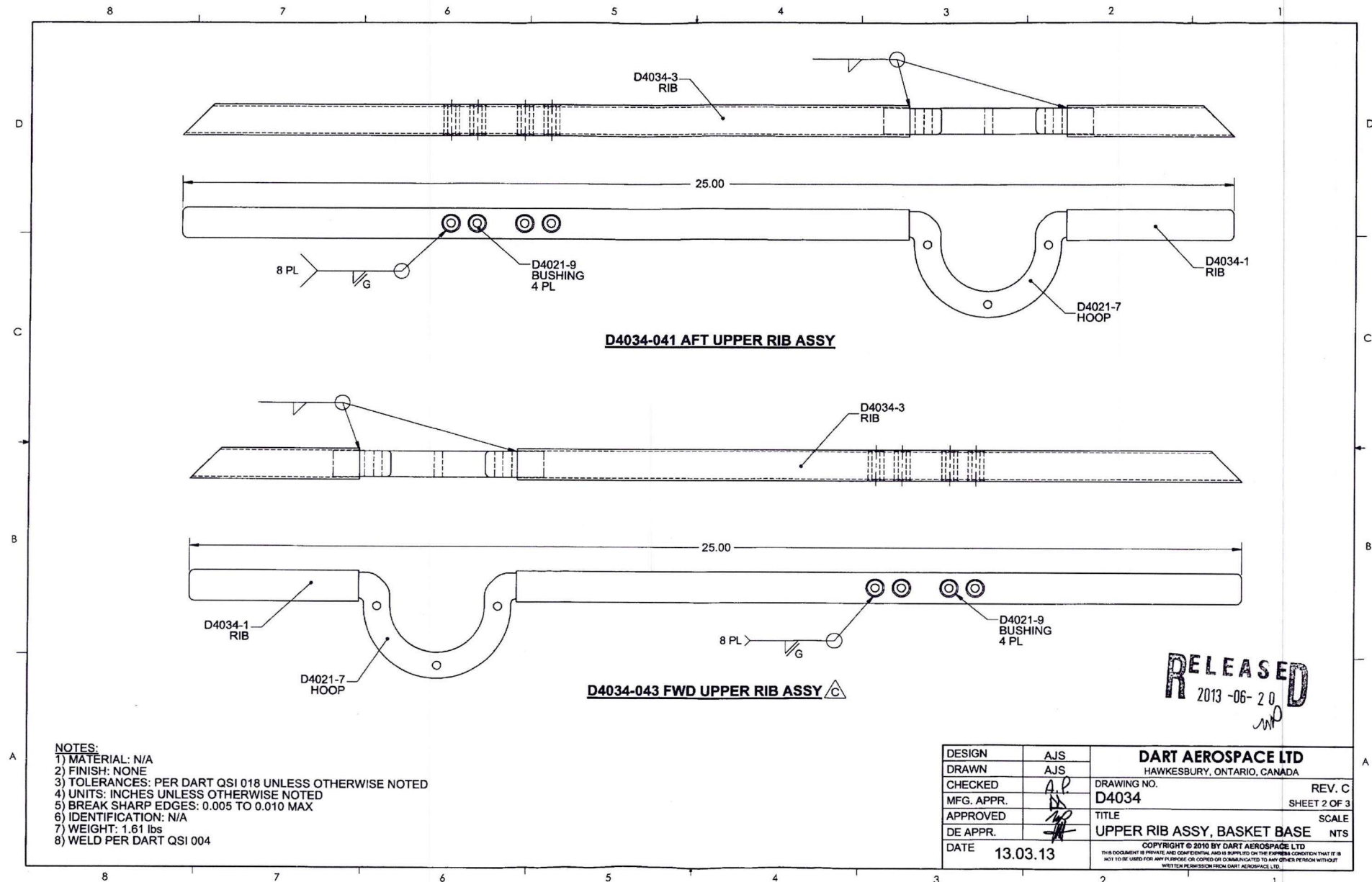
D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
2013-06-20

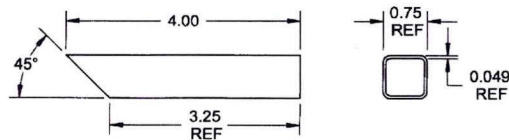
C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.	AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	AS	D4034	SHEET 1 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	UPPER RIB ASSY, BASKET BASE	NTS
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



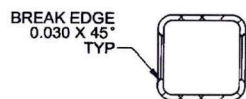
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.61 lbs
 - 8) WELD PER DART QSI 004

RELEASED
2013-06-20

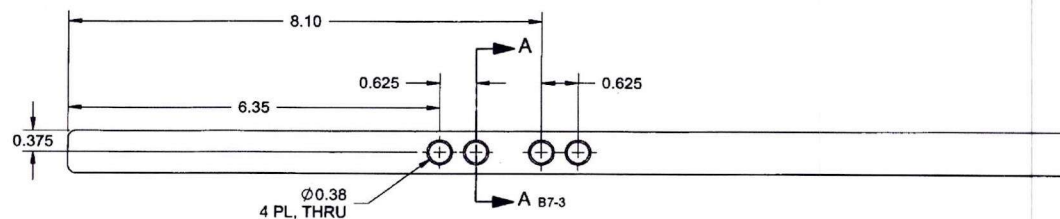
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	[Signature]	D4034	SHEET 2 OF 3
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	UPPER RIB ASSY, BASKET BASE	NTS
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D4034-1 RIB



SECTION A-A C3-3



D4034-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

RELEASED
2013-06-28

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	AP	D4034	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	UPPER RIB ASSY, BASKET BASE	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					